



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3078-042
Job Sheet 169076



Part No: D3078-042

Job Qty: 2 ea

Part Name: Step Assembly, Hi Short RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/30/17

Job Tracking No:

Due Date: 12/15/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 15.10.21 NEW ISSUE DD VERF:JLM IPP REV:B 15.11.12 REV:C3 DD VERF:JLM
IPP REV:C 16.03.15 DWG REV:B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/14/17	0.00	0.00	Start Up Large Fab-4		D.M.L 17-11-30
110	Large Fab	2 pcs		12/14/17	0.00	2.40	Large Fab 8		St 17-12/04 D.M.L
120	QC	2 pcs		12/14/17	0.00	0.00	QC6		PD 17-12-04
130	Large Fab	2 pcs		12/14/17	0.00	2.40	Large Fab 2		SL 17-12-07
140	QC	2 pcs		12/14/17	0.00	0.00	QC9		g DAS
150	QC	2 pcs		12/14/17	0.00	0.00	QC5		g DAS
160	HandFinish	2 pcs		12/14/17	0.00	0.42	HandFinish1		2017-12-06 JX
170	QC	2 pcs		12/14/17	0.00	0.00	QC7-2		Cpl
200	Large Fab	2 pcs		12/14/17	0.00	2.40	Large Fab 2	-45 Min	17-12-18 SC
210	QC	2 pcs		12/14/17	0.00	0.00	QC10		CPC
220	QC	2 pcs		12/14/17	0.00	0.00	QC5		CPC
230	HandFinish	2 pcs		12/14/17	0.00	0.42	HandFinish6		BEB 17-12-19
240	Powdercoat	2 pcs		12/14/17	0.00	0.38	Powdercoat1		DR 17-12-20
250	HandFinish	2 pcs		12/15/17	0.00	0.42	HandFinish3		BEB 17-12-21
260	QC	2 pcs		12/15/17	0.00	0.00	QC3		TD 17 DEC 22 017
290	Packaging	2 pcs		12/15/17	0.00	0.00	Packaging3-1		Y.A.
300	QC21-SA	2 Ea		12/15/17	0.00	0.00	QC21		

Part Op 110 - 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

Descriptions: 130 - 1-Bevel end for welding FWD ONLY 2-Weld Support, weld Fwd End Plate as per QSI 004 & Dwg D3078

A/RAluminum Rod

200 - 1- Rivet Leg Assembly as per Dwg D3078. 4-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod

240 - START TIME: 11:10 CUT: 320° FINISH: 11:40

M138467

Wing walk M138711

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2622-120C	1	98	0	0
	D3067-1	2	66	0	0
	D3219-3	4	25	0	0
200-Large Fab	D3065-041	2	21	0	0
	D3066-1V	4	138	0	0
	D3067-1V	2	66	0	0
	MS20600-AD4W4V	32	57	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
 S015965 Step Assembly, Hi Short RH PART NO: D3078-042 Revision: Operation: Start up Operation Change No: Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

FAULT CATEGORY

ect te/Unqualified	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
	☐ Weld	☐ Part Incorrect
	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Mislabeled	☐ Finish
	☐ Fit/Function	☐ Misread
	ete/Unclear	☐ Misaligned/off center

 Misidentified ☐ ☐ Past Due ☐ OTHER : _____



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Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D3065-041 Revision: Step Leg Assembly														
130	QC21-SA	S024281	169076	0 Ea	0	166514	WA002		Stock	12/18/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Part Number: D3066-1 Revision: Spacer														
160	QC21-SA	S024274	169076	0 Ea	0	S012395	WA003	Bin	Stock	12/18/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Part Number: D3067-1 Revision: End Plate														
160	QC21-SA	S024277	169076	0 Ea	0	S012005	WA003		Stock	12/18/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Part Number: MS20600-AD4W4 Revision: Rivet														
100	Receive Ea	S024271	169076	32 Ea	0	S016823	CCK004		Stock	12/18/2017	Issue Container			
Operation Totals:		1		32	0									
Part Totals:		1		32	0									
Totals:		4		32	0									

Plex 1/8/2018 8:55 AM Dart.Boucher.Sylvie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					